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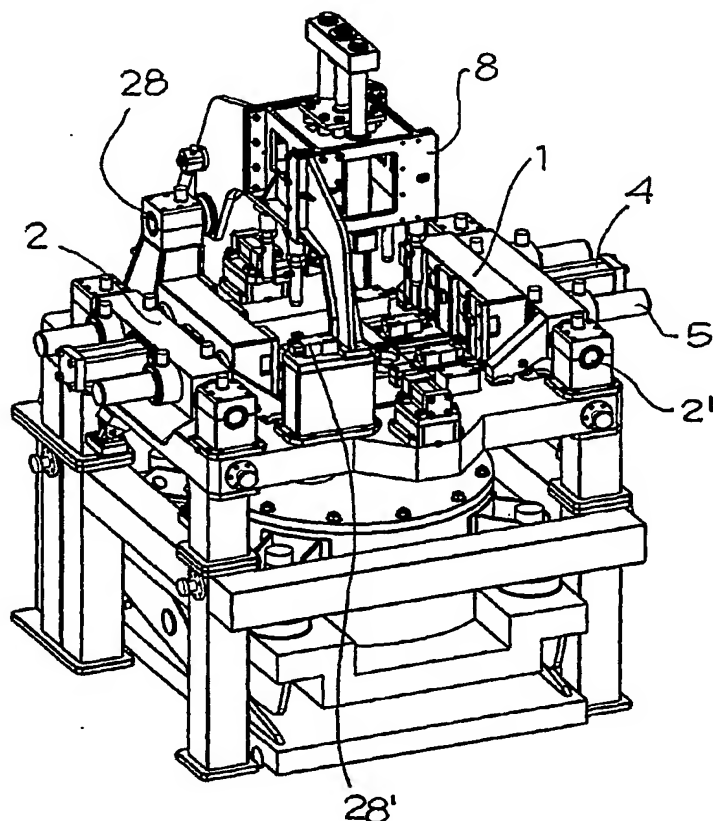
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- (71) Applicant (for all designated States except US): **MECCANICA BASSI S.P.A.** [IT/IT]; Via Triumplina 83, I-25123 Brescia (IT).
- (72) Inventor; and
- (75) Inventor/Applicant (for US only): **BASSI, Bruno** [IT/IT]; Via Panoramica 18, I-25128 Brescia (IT).
- (74) Agents: **CRIPPA, Paolo, Ernesto et al.**; Jacobacci & Partners S.p.A., Piazzale Arnaldo 2, I-25121 Brescia (IT).
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(54) Title: **BENCH, MOLD AND CASTING PROCEDURE, IN PARTICULAR FOR ENGINE CYLINDERS HEADS**



(57) Abstract: This invention regards a bench (1,16, 17, 29, 30, 31), a mold and a casting procedure, particularly for engine cylinders heads, characterised by a low-pressure casting, that is the introduction of molten metal from a furnace (32) into a mold positioned above it by exercising pressure on the surface of the molten metal inside the same furnace, combined with a gravity feeding of the same mold. Gravity casting takes place with open risers created in the mold, the latter being sealed at the top, at least at the level of these risers, by lids moved by a tilting arm joined to the casting bench.

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